

Date: Tuesday, 11/14/2006 10:08:31 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP WELDMENT		
Job Number	: 29411 7		Part Number	: D3562041		
Estimate Number	: 12576		Drawing Number	: D3562 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/14/2006 S.O. No. : N/A		Drawing Revision	: A		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 11/24/2006		
Previous Run	: 29411		Qty:	5 Um: Each		
Written By	: <i>KJ 06/11/14</i>					
Checked & Approved By	: <i>KJ 06/11/14</i>					
Comment	: Est Rev:A New Issue 06-11-09 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>328215</i>

Check Material for any Dents or Defects

LE. 06.11.22 5

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

E
1-Cut D2622 extrusion ~~to 0.5000 long~~ as per Dwg D3562

2-Deburr and bevel ends for welding

LE. 06.11.22 5
LE. 06.11.23 5

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:	Qty	Part Number	Description	Batch
	2	D2734	End Cap	<i>329340</i>

LE. 06.12.27 5

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:08:31 AM
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Drawing Name: STEP WELDMENT

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Part Number: D3562041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D35601 ARM



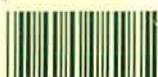
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3560-1 Arm 329447

S.E. 06.12.27 5

6.0 D35603 ARM



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

ARM

Batch: 329449

S.E. 06.12.27 5

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld arms and end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

Use DT8893 To Weld Arms

A/R Aluminum Rod m100237 & m19612

S.E. 06.12.28 5

2-Grind end cap welds flush as per Dwg D3562

S.E. 06.12.28 5

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Mo7/01/03 (S)

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Mo7/01/03 (S)

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1.

FC/08 07/01/04 (S)

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Deburr and bevel aft end for welding.

S.E. 07.01.08 5

2-Weld as per Dwg D3562

a/r AL ROD Batch: m100237 m19612

S.E. 07.01.08 5

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-01-10	11b.	grind end cap flush .	ll.	07-01-09	5		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/09
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:08:31 AM
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Process Sheet

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Drawing Name: STEP WELDMENT

Job Number: 29411

Part Number: D3562041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/01/10 (5)

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/10 (5)

14.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

KL

07/01/11 X 5

15.0 POWDER COATING POWDER COATING



M102391

PTB

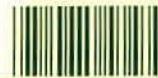
Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

KL

07/01/11 X 5

16.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: 102078

SE/KL

07/01/11 (5)

17.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf

07-03-26

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18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

07/04/05

W. A. MWS

Job Completion



W/O:

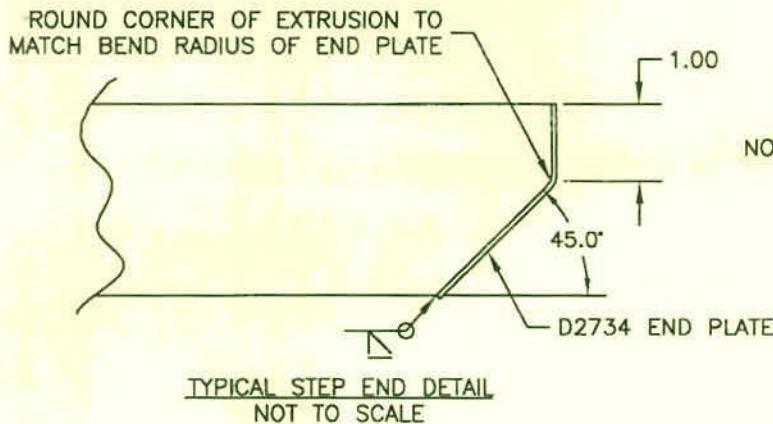
WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

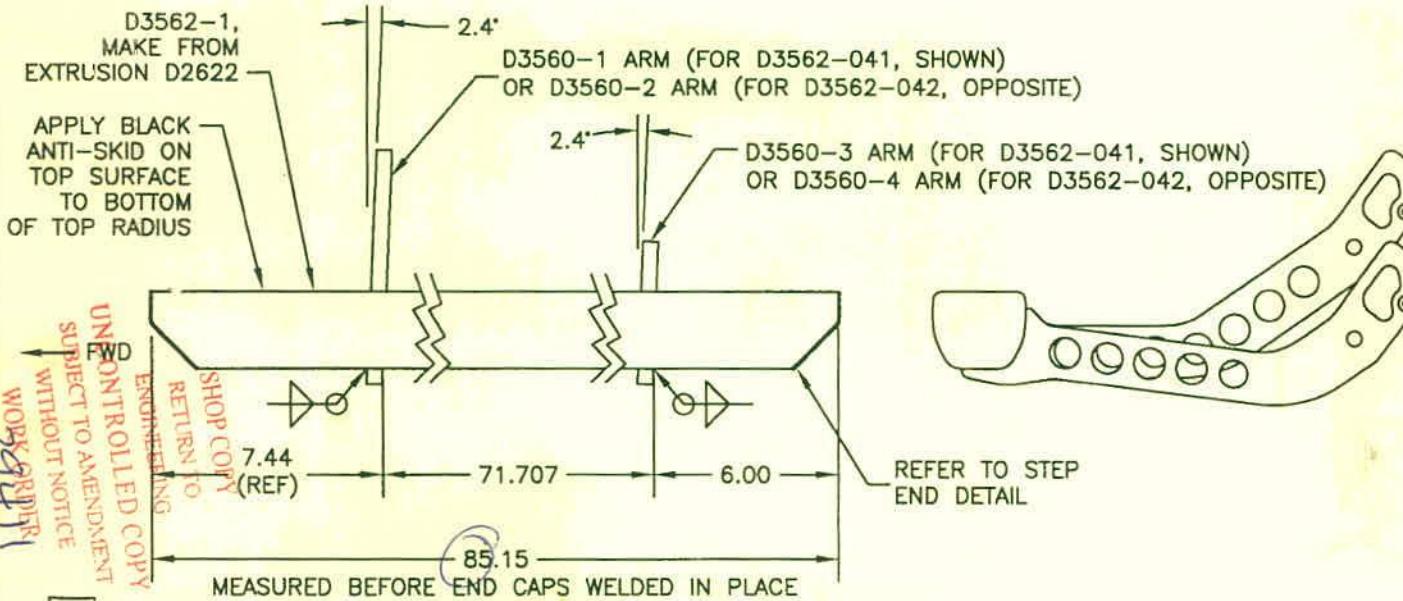
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/21	15	Scratches on skip		Refaint 1	PL 07/21	6		

NOTE: Date & initial all entries



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

DART



D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
90	90	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>W</i>	<i>W</i>	D3562
DATE		TITLE
06.09.26		STEP WELDMENT
A	06.09.26	NEW ISSUE

